

Work Order ID 63270

Wednesday, October 27, 2010 9:06:39 AM



Page 1

Item ID: D212-725-1-151F

Accept



Setup Start



Revision ID:

Item Name: Support Angle Oil Cooler

Stop



Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

MS

Date: 10-10-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

E

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2024.040

1-Cut as per Dwg

Dwg Rev: *F*

Prog Rev: *E*

2-Deburr if necessary

10-10-27

②

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D212-725-1-151F

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Revision ID:

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Item Name: Support Angle Oil Cooler

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check 0.00



QC Memo 0.00

Quality Control

121 Hand Finish

Acid to Alodine

122 Qc 3

10/10/28

130 Identify as per dwg & Stock Location: 0.00



Packaging Memo 0.00

Packaging ***FLAT PATTERN ONLY***

140 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

10/10/27

(+2)

2

BR 10-10-28

2

φ

10/10/28 (2)

10/10/29

BR 10-10-28

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 9:06:43 AM

Page 1

Work Order ID: 63270



Parent Item: D212-725-1-151F



Parent Item Name: Support Angle Oil Cooler

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

315.6400

0.1966

0.413895



H30-10-27

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT

78.1

114415

78.1

MAT22

237.54

110305

21.93

111786

13.76

112291

28.25

112331

52

113162

121.6

111786

2

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NOTE: Date & initial all entries

D 212-725-1-151F

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Measured by: RB	Audited by: S	Prototype Approval:
Date: 10-10-27	Date: 10/10/27	Date:

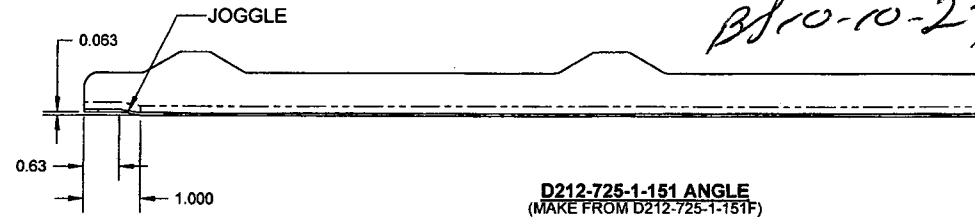
H:\FORMS\Quality Assurance\approved QA\FAI revD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

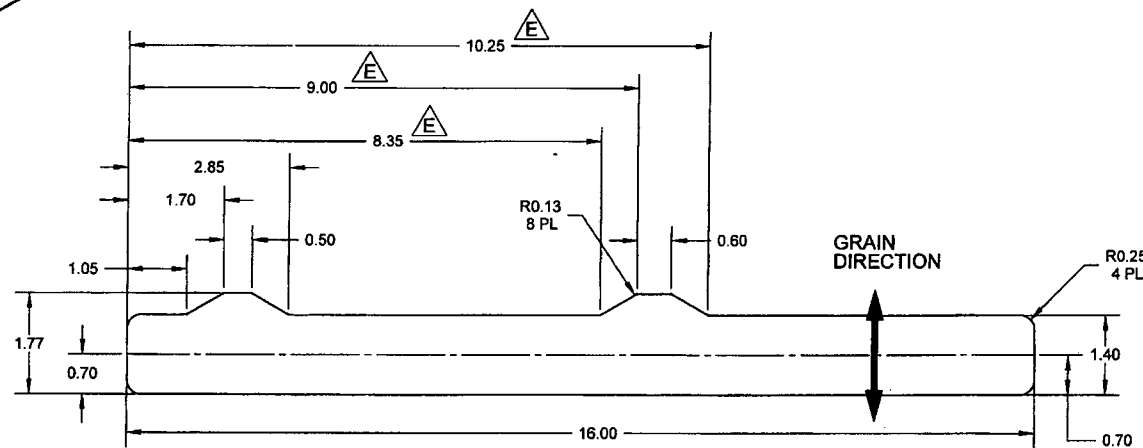
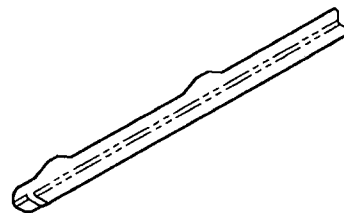
WITHOUT NOTICE
WORK ORDER

NO. 43220

BS10-10-27





D212-725-1-151 ANGLE
(MAKE FROM D212-725-1-151F)



D212-725-1-151F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D212-725-1	SHEET 51 OF 82
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	08.09.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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RELEASED
2009-10-28

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